

# Work Order ID 53019

October 22, 2009 9:44:11 AM



Page 1

Item ID: D2656-37

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 21/10/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: *PS*

Date: *09-10-22*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2656

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2656 ☒ Dwg Rev: *D* ☐ Prog Rev: *D* ☐ 2-  
Deburr if necessary

*B 9-11-3*

*(B)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 9-11-3*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*=> 8 or 163*

*(H.3)*

# Work Order ID 53019

October 22, 2009 9:44:11 AM



Page 2

Item ID: D2656-37

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

*N/A*

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. □2-  
Identify as D2656-37

*SS 09/11/17*

*13*

*0*

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*=> 02/11/17*

*(13)*

*0*

# Work Order ID 53019

October 22, 2009 9:44:11 AM



Page 3

Item ID: D2656-37

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 21/10/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005.4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:00AM

OVEN TEMPERATURE:

9:30AM FINISH TIME

320F

Handwritten: 09/11/09

Handwritten: X13

Handwritten: 0

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: 09-11-09

Handwritten: X13

Handwritten: 0

180

Identify as per dwg & Stock Location:

FP.20

0.00



Packaging

Memo

0.00

Packaging

Handwritten: 09/11/09

Handwritten: X13

Handwritten: 0

**Work Order ID 53019**

Page 4

October 22, 2009 9:44:11 AM

Item ID: D2656-37

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19

R 09-11-19

(13)

# Picklist Print

October 22, 2009 9:44:19 AM

Page 1

Work Order ID: 53019



Parent Item: D2656-37RevD



Parent Item Name: Wearshoe


Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S20GA  1010/1025 SHEET		Purchased	No			100	sf	158.5000	6.7971	7.3635		



18 9-11-3

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	158.5	
102684	1	
103258	1.5	
103788	2	
103840	2	
104184	1.54	
104921	8.5	
106069	2	
106478	4	
106671	1.46	
107906	2	
108275	3	
109289	1.5	
111410	128	

111410

13

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53019
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D2656-37
<b>Inspection Dwg:</b> D2656 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300 x 0.300	+/-0.010	307 x 308	✓			
1.885	+/-0.010	1.887	✓			
2.000	+/-0.010	2.000	✓			
4.750	+/-0.010	4.750	✓			
9.500	+/-0.010	9.500	✓			
14.250	+/-0.010	14.250	✓			
17.750	+/-0.010	17.750	✓			
22.500	+/-0.010	22.500	✓			
27.250	+/-0.010	27.250	✓			
30.750	+/-0.010	30.750	✓			
0.040	+/-0.010	0.035	✗			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-16-03	<b>Date:</b> 09/16/03	<b>Date:</b>	N/A

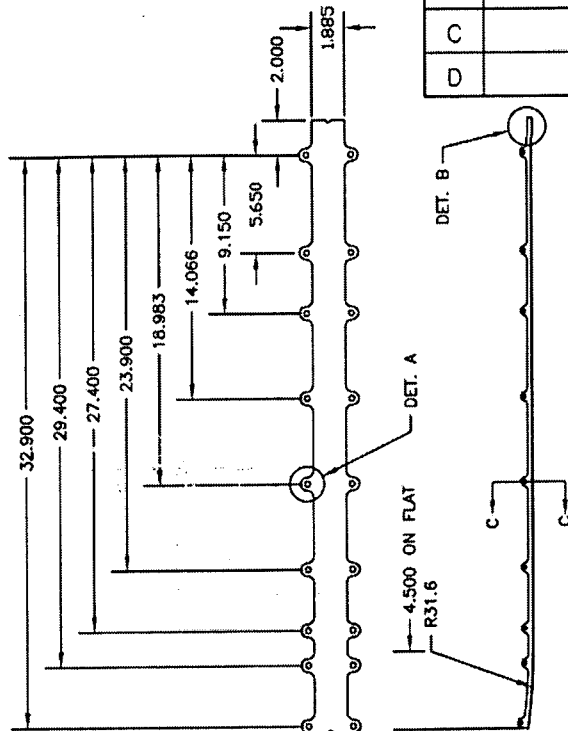
Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	
B	08.11.27	Dimensions updated per Dwg Rev. D	KJ/EC	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53019 B/09-10-22

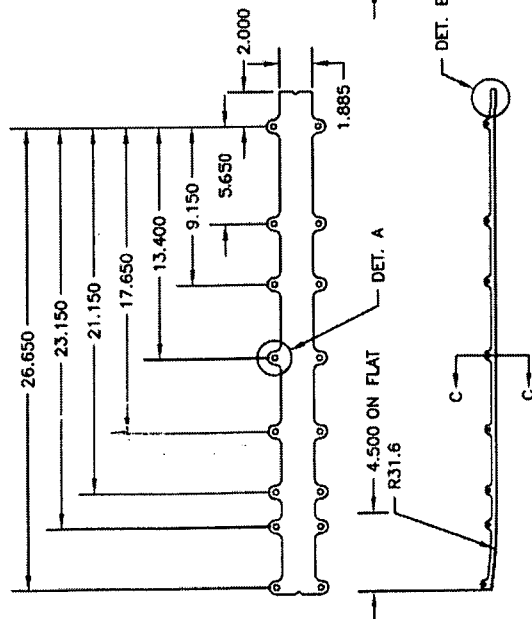


DESIGN <b>DS</b>	DRAWN BY <b>CP</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2656</b>	REV. D SHEET 1 OF 4
DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

**D2656-13**



**D2656-11**

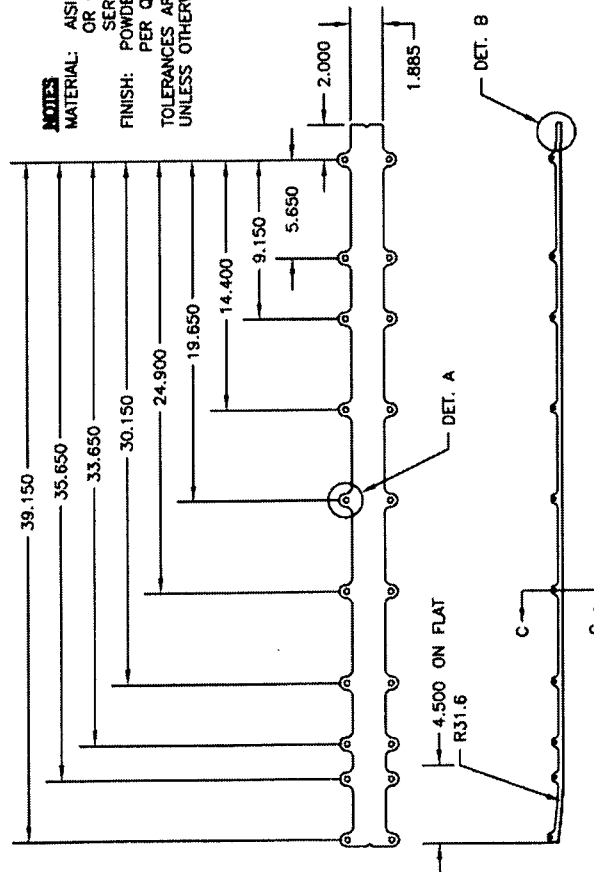


**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

RELEASED  
05-09-08

**D2656-15**



Copyright © 1997 by DART AEROSPACE USA, INC.

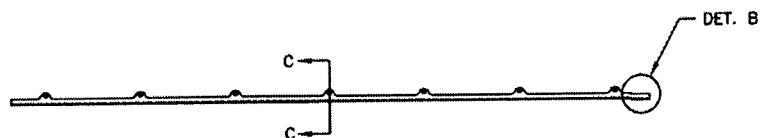
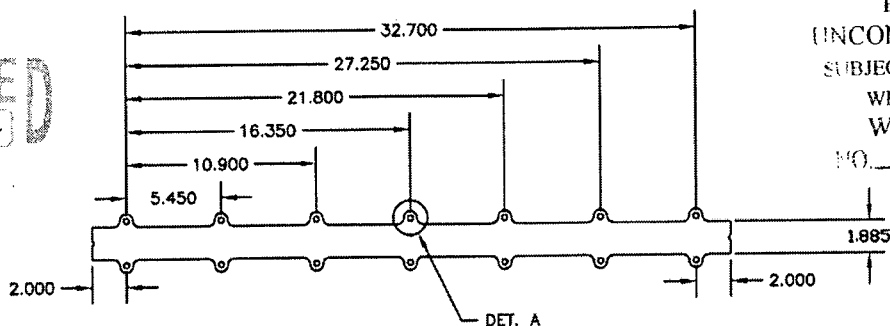
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



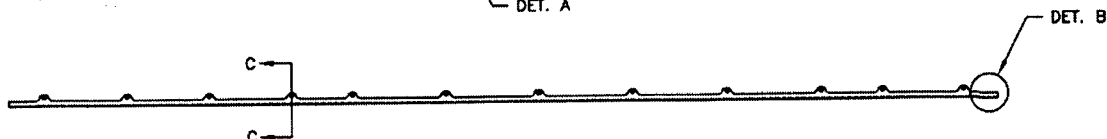
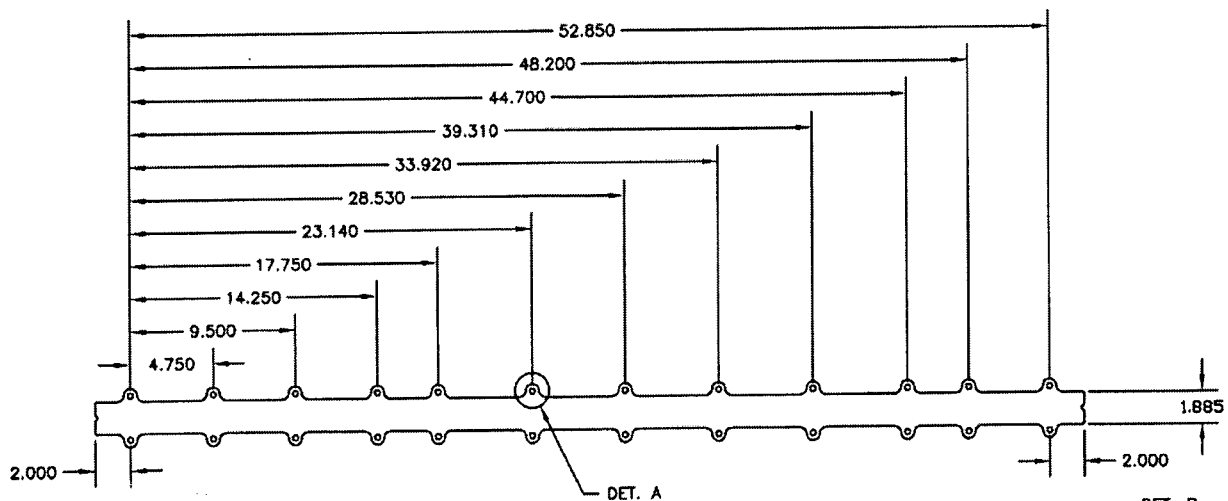
DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17		TITLE WEARSHOE SCALE 1:10	

RELEASED  
05.01.06

### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

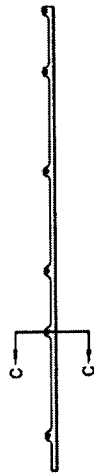
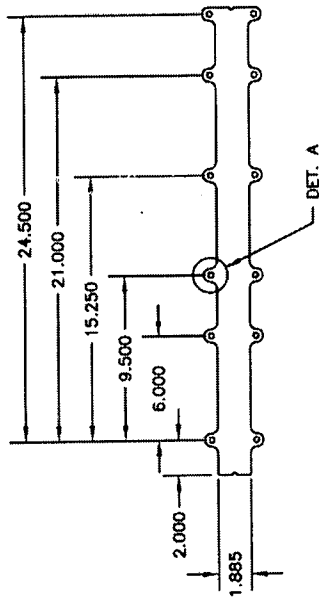
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



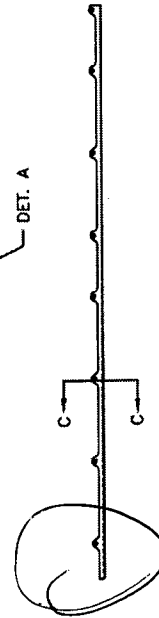
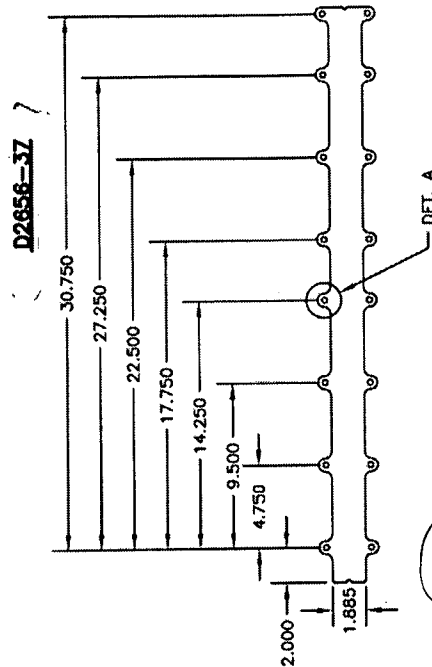


DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2656	REV. D SHEET 3 OF 4
DATE 05.08.17		TITLE WEARSHOE SCALE 1:10	

D2656-33



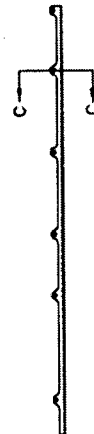
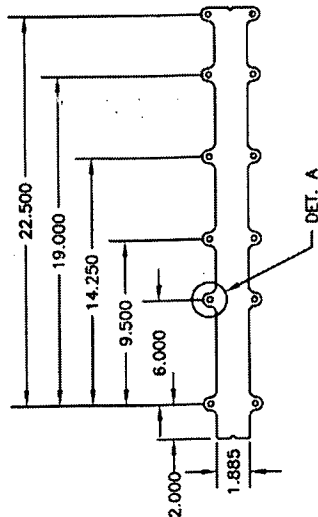
D2656-37



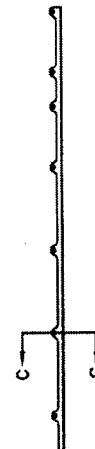
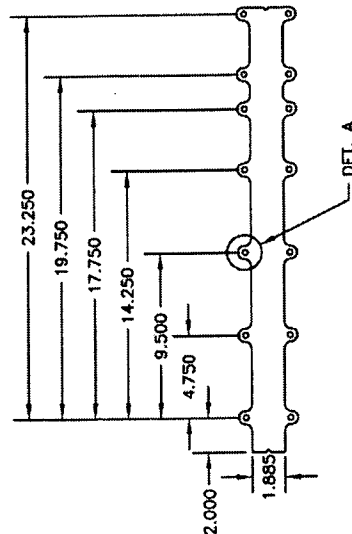
UNCONTROLLED COPY  
SUBJECT OF MODIFICATION  
WORK ORDER  
NO. 53019

RELEASED  
05.09.06

D2656-31



D2656-35



NOTES  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W  
FINISH: SERIES STEEL, 20 GAUGE (0.040 THICK)  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

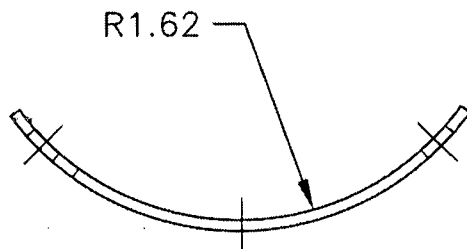
Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

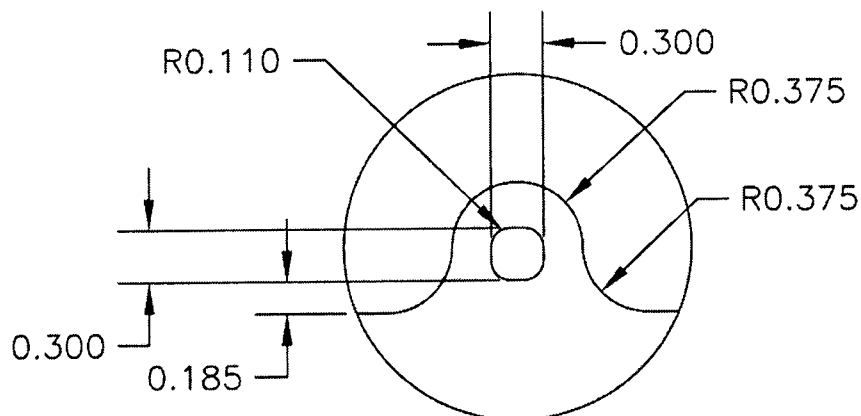
### SECTION C-C



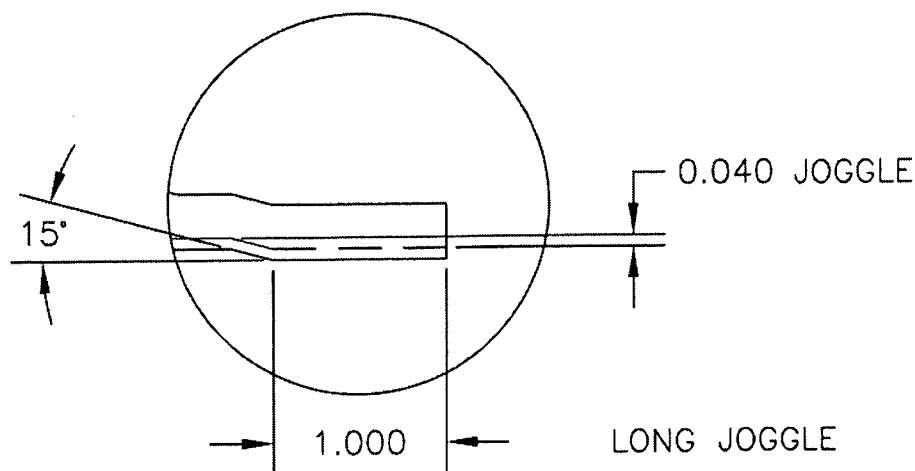
RELEASED  
05-09-06

SHOUL ONLY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53019

### DETAIL A



### DETAIL B



Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.